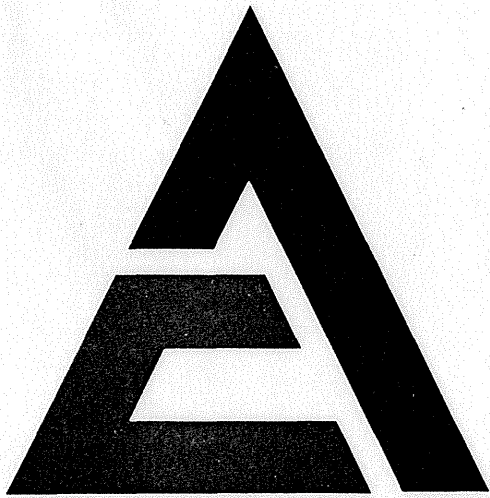


Parts
Catalog
for
645 M
(FSN 3805-051-9359)
WHEEL
LOADER
(S/N 8001-9176)

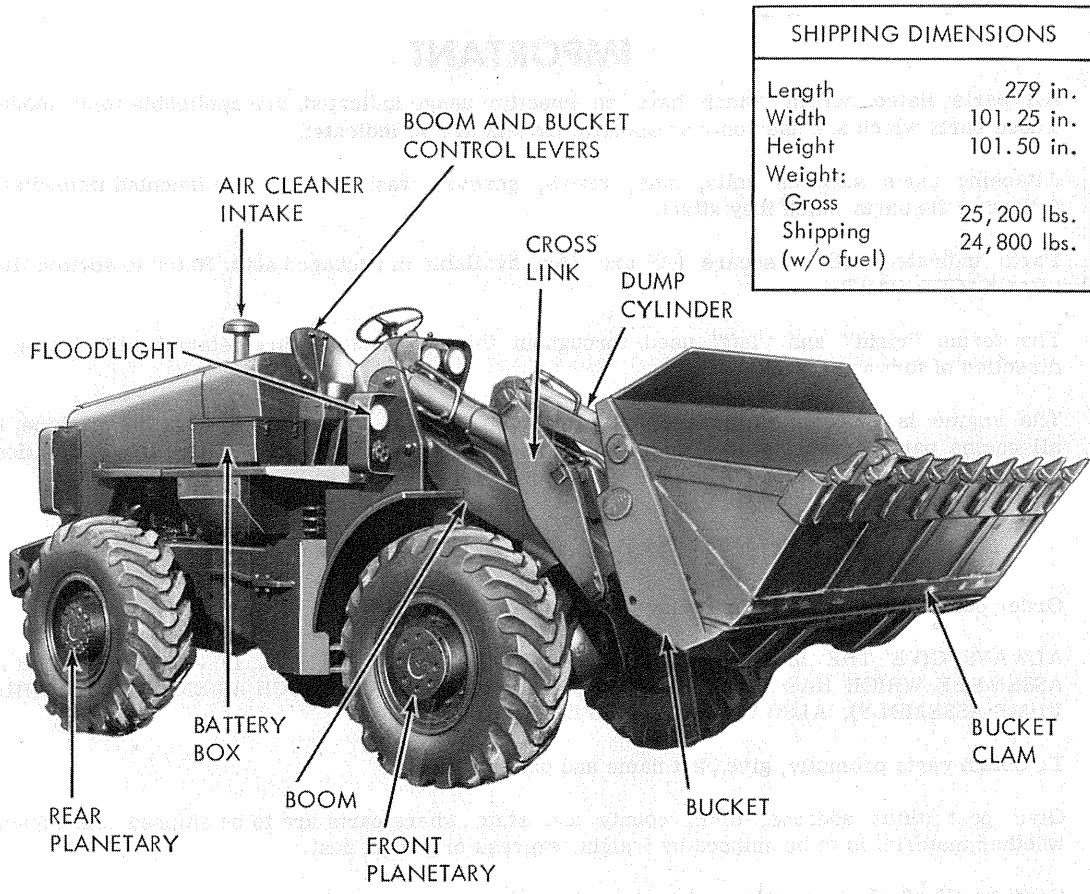


ALLIS-CHALMERS

NOTICE Allis-Chalmers Corporation and FIAT S.p.A. entered into a joint venture agreement to combine their manufacture, sale and service of construction machinery, products throughout the world after January 1, 1974. In view of the new enterprise, wherever in this publication reference is made to Allis-Chalmers or your Allis-Chalmers dealer, such reference is intended to identify FIAT-ALLIS Construction Machinery Inc. or your FIAT-ALLIS dealer.

**CONSTRUCTION MACHINERY DIVISION
 SPRINGFIELD, ILLINOIS 62705**

FORM 3055044-6



SHIPPING DIMENSIONS	
Length	279 in.
Width	101.25 in.
Height	101.50 in.
Weight:	
Gross	25,200 lbs.
Shipping (w/o fuel)	24,800 lbs.

MODEL IDENTIFICATION

IMPORTANT

All parts listed herein, which have no specific usage indicated, are applicable to all models. Those parts which are used only on specific models are so indicated.

Attaching parts such as bolts, nuts, rivets, screws, washers, etc., are indented immediately following the parts which they attach.

Parts indicated with a square (□) are also available in packaged sets. Refer to section titled "PACKAGED PARTS".

The terms "right" and "left" used throughout this parts catalog are determined by facing the direction of forward travel.

The engine is mounted unconventionally with the flywheel toward the front of the machine, but all engine parts are designated in respect to the engine as it would be installed in a conventional machine with the flywheel to the rear.

INSTRUCTIONS FOR ORDERING PARTS

Order parts from the dealer covering the local territory.

ALWAYS GIVE THE MODEL AND SERIAL NUMBER OF MACHINE. IF PARTS ARE FOR AN ASSEMBLY WHICH HAS A MODEL AND/OR SERIAL NUMBER (SUCH AS ENGINE ASSEMBLY, PUMP ASSEMBLY), ALSO INCLUDE THIS INFORMATION.

To obtain parts promptly, give part name and part number.

Give post office address, town, county and state where parts are to be shipped. Also specify whether material is to be shipped by freight, express or parcel post.

Confirm all telephone or telegraph orders in writing.

Parts for standard motor accessories such as generators and starting motors should be ordered from authorized Service Stations maintained by manufacturers of these units throughout the country.

No credit will be allowed on parts unless they are returned to the dealer from whom they were purchased; from there they will be returned, at the customer's expense, to the factory for inspection.

Unless claims for shortages or errors are made immediately upon receipt of goods, they will not be considered.

When broken goods are received, a full description of the damage should be made by the carrier agent on the freight bill. If this description is insisted upon, full damage can always be collected from the transportation company.

No responsibility is assumed for delay or damage to merchandise while in transit. Our responsibility ceases upon delivery of shipment to the transportation company from whom a receipt is received showing that shipment was in good condition when delivered to them; therefore, claims (if any) should be filed with the transportation company and not with Allis-Chalmers.

The right is reserved to change the construction or material of any parts where it seems desirable to do so without incurring the obligation of installing such changes on units already delivered.

The information contained herein is general in nature and is not intended for specific application purposes. Allis-Chalmers reserves the right to make changes in specifications shown herein or add improvements, at any time without notice or obligation.

MODEL IDENTIFICATION

The symbol listed below is stamped in front of the model serial number on each unit.

MODEL SYMBOL	ENGINE MODEL	DESCRIPTION
645	3500	Turbocharged Diesel powered engine, articulated four wheel drive loader unit of "modular" design, equipped with: power shift transmission, torque converter, planetary axles, power steering and power brakes.

RECORD YOUR SERIAL NUMBERS BELOW

LOADER SERIAL NO. _____

ENGINE SERIAL NO. _____

TRANSMISSION SERIAL NO. _____

AXLE SERIAL NO. _____

SERIAL NUMBER LOCATIONS

LOADER SERIAL NO: On a plate attached to the left side of the bonnet in rear of the operators seat.

ENGINE SERIAL NO: On a plate attached to the right hand side of the engine block above starting motor.

TRANSMISSION SERIAL NO: On plate attached to the right side of the transmission housing.

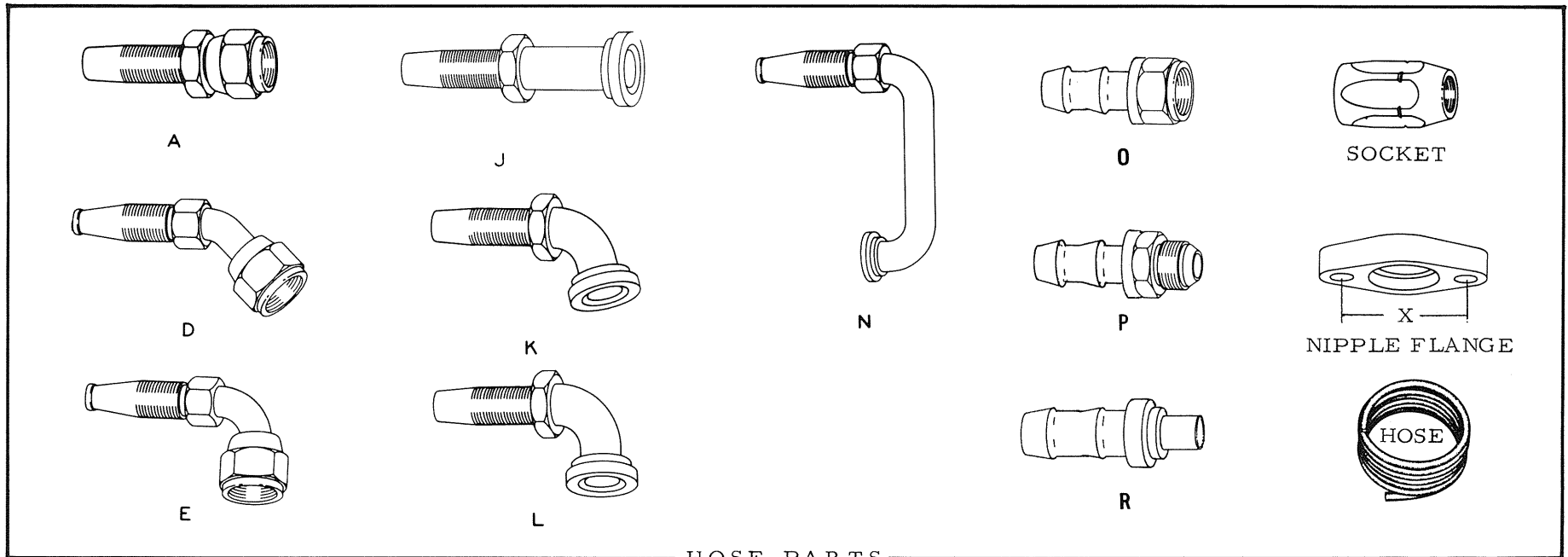
AXLE SERIAL NO: On plate attached to the axle housing.

ALPHABETICAL INDEX

Air Application Valve Assy.	138	Drive Shaft Group	84
Air Brake Lines	132	Dump Cylinder Assembly	166
Air Cleaner	46	Elements	
Air Compressor	120	Air Cleaner	46
Air Tank, Horn & Lines	128	Fuel Filter	33
Alcohol Evaporator	119	Hydraulic Tank	170
Alternator Assembly	218	Oil Filter	30
Alternator, Voltage Regulator & Hour Meter	216	Transmission Oil Filter	83
Axle Housing Assembly (Front Axle)	95	Engine Controls	49
Axle Housing Assembly (Rear Axle)	103	Engine and Mounting	11
Axle & Support	90	Exhaust Manifold	32
Batteries, Cables & Box	196	Filters	
Blackout Light Assy. (Tail Light)	205	Engine Oil	30
Brake Assembly (Front Axle)	110	Fuel	33
Brake Assembly (Rear Axle)	112	Hydraulic Tank	170
Bucket Hydraulics	192	Transmission Oil	83
Bucket Position Indicator	195	Flex Disk & Converter Drive	56
Clutch Cut-Off Valve	118	Flywheel Assembly	23
Cold Weather Primer	48	Flywheel Housing	22
Compressor Crankcase	124	Forward Clutch & Planetary	68
Compressor Cylinder Block	122	Frame	182
Compressor Cylinder Head	125	Fuel Filter	33
Control Valve Assembly	173	Fuel Tank and Lines	34
Cowl and Platform	180	Governor (Compressor)	126
Crankshaft	14	High Range Clutch & Transfer Drive Group	70
Cylinder		Hydraulic Brake Lines	115
Bucket (Multi-Purpose)	194	Hydraulic Brake Lines (Rear Section)	116
Dump	166	Hydraulic Controls	158
Lift	168	Hydraulic Piping	156
Power Steering	146	Hydraulic Piping & Cylinders (Front Section)	162
Wheel	114	Hydraulic Pump	160
Cylinder Block	12	Hydraulic Pump & Piping	165
Cylinder Head	18	Hydraulic Tank and Valve	170
Cylinder Parts	194	Idler Gear Assembly	17
Demand Valve Assembly	154	Injection Nozzles and Lines	40
Differential Carrier Assy. (Front Axle)	92	Injection Pump	38
Differential Carrier Assy. (Rear Axle)	100	Instrument Panel and Gauges	206
Drive Shaft Assembly	85-88	Intake Manifold	31

ALPHABETICAL INDEX

Ladder, Hand Rail and Fenders	178	Shaft and Hub (Rear Axle)	104
Lift Cylinder Parts	168	Slave Receptacle, Relay, Polarity	
Light Assembly	204	Protector, Resistor and Circuit Breaker	198
Light Assembly Parts	203	Starter, Rotor, Stator and Drive	214
Linkage Group	188	Starter Solenoid and Brush Plate	212
Manifold		Starting Motor and Solenoid	210
Exhaust	32	Steering Cylinder and Piping	152
Intake	31	Steering Gear Assembly	142
Multi-Purpose Bucket	190	Steering Gear and Linkage	141
Nozzle Holder Assembly	39	Steering Pump, Demand Valve & Lines	148
Oil Cooler	28	Thermostat and Housing	52
Oil Filter	30	Tie Rod Assembly	145
Oil Pan	25	Timing Gear Housing	24
Oil Pump	26	Tool Box	187
Packaged Parts	8	Torque Converter	58
Parking Brake Assembly Parts	107	Torque Converter Housing	60
Parking Brake Control	108	Transmission	54
Pintle	186	Transmission Charging Oil Pump	74
Piston and Connecting Rod	16	Transmission Control Group	78
Power Cluster Parts	135	Transmission Control Valve	76
Power Steering Cylinder	146	Transmission Cooling Lines & Dipstick	81
Power Steering Pump Assembly	151	Transmission Filter and Mounting	82
Power Takeoff	75	Transmission Housing and Covers	64
Primer Pump and Lines	36	Transmission Oil Filter	83
Pump		Turbine Driven Gears & Freewheel Unit	62
Engine Oil	26	Turbocharger	42
Hydraulic	160	Turbocharger Assembly Parts	44
Injection	38	Universal Joint Cartridge & Support	89
Power Steering	151	Valves	
Primer	36	Air Application	138
Transmission Charging Oil	74	Clutch Cut-Off	118
Water	50	Control	173
Radiator	53	Demand	154
Radiator Support, Hood and Fenders	179	Transmission	76
Rear Output Group	72	Valve Operating Mechanism	20
Reverse Clutch and Planetary	66	Water Pump and Fan	50
Seat and Mounting	184	Wheel Cylinder Assembly	114
Shaft and Hub (Front Axle)	96	Wheel Group (3 Piece Rim)	177
		Wiring, Lights & Turn-Signal	200



HOSE PARTS

NOTE: Refer to right hand column for identity of interchangeable crimped-type hose (fittings not re-usable). Assembly number shown in left hand column indicates available replacement hose assembly with re-usable components; where no assembly number is listed, hose assembly is not available from factory but may be constructed in the field from data indicated.

HOSE ASSEMBLY NO. (See NOTE)	BULK HOSE (25' roll)	HOSE LENGTH (inches)	NIPPLE (#1 end)			NIPPLE (#2 end)			SOCKET (both ends)	NIPPLE FLANGE		CRIMPED-TYPE HOSE (See NOTE) Part No.
			Including SOCKET	NIPPLE only	Type	Including SOCKET	NIPPLE only	Type		Part No.	X Dim	
654271	919474	22-1/2		921046	A		921046	A	919469			
3050811	925782	22-1/2	925791		J		925791	J				
3050812	925782	58-3/4	925791		J		925791	J				
3050813	925764	33-1/2	920944	920978	A	920962	921564	D	920972			
3050844	925782	46-1/2	925793		L	925792		J				
3050849	925764	31-1/2	920952	923186	E	920944	920978	A	920972			
3050851	925773	77-1/2	920951	921563	E	920961	921302	D	920971			
3050852	920221	56	920852	920344	A	920867	919277	D	919281			
3050853	920221	42	920852	920344	A	920867	919277	D	919281			

3050854	925764	65-1/2	920957		E	920957		E	920972			
3050855	925782	27-1/4	925803		N	925794		L				
	925773	41-1/2	920942	921562	A	920942	921562	A	920971			3050856
3050857	925782	29-3/4	925796		K	925795		L				
3050859	925780	46-5/8	925780		L	925775		A			2-1/2	
	925768	43-3/8	920805		O	925777						3050972
	925768	21-1/2	920805		O	920805		O				3050973
	925769	24-1/4	920389		P	920806		O				3051032
3051185	925764	14-1/2	920962	921564	D	920952	923186	E	920972			
3051186	925764	14-1/2	920944	920978	A	920952	923186	E	920972			
	925768	38-5/8	920829		R	920805		O				3052029
3052036	925771	31-1/2	925774		A	925774						
3052037	925771	33-1/2	925774		A	925774		A				

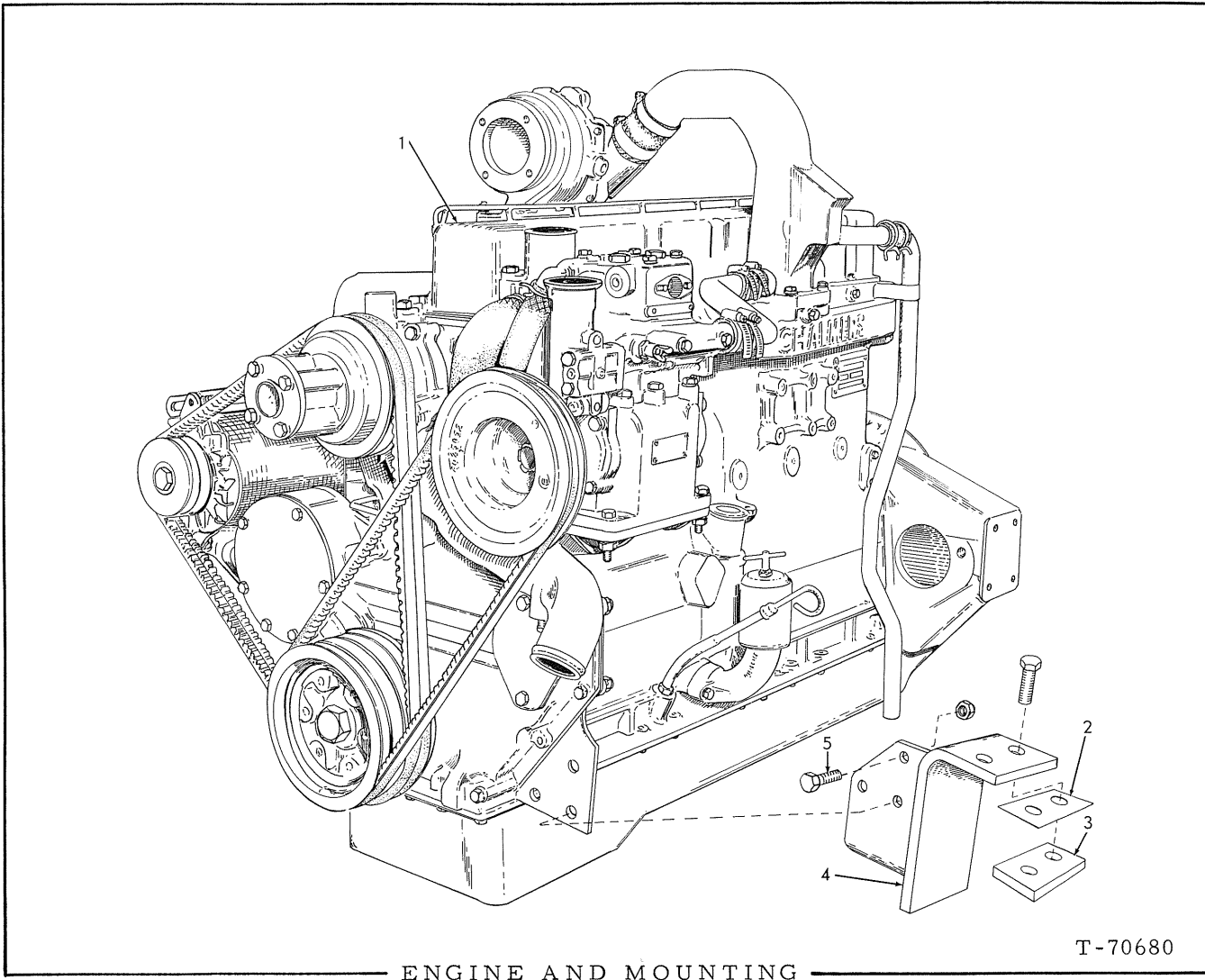
PACKAGED PARTS

PACKAGE NO.	DESCRIPTION
-----	REPAIR KIT, cylinder (See DUMP CYLINDER)
-----	REPAIR KIT, cylinder (See LIFT CYLINDER)
-----	REPAIR KIT, cylinder (See POWER STEERING CYLINDER)
-----	REPAIR KIT, master cylinder (See POWER CLUSTER ASSEMBLY)
-----	REPAIR KIT, power cluster (See POWER CLUSTER ASSEMBLY)
-----	REPAIR KIT, wheel cylinder (See WHEEL CYLINDER ASSEMBLY)
-----	REPAIR KIT, valve (See AIR APPLICATION VALVE)
-----	LINING KIT (See BRAKE ASSEMBLY)
-----	RING SET, piston (See PISTON AND CONNECTING ROD)
-----	REPAIR KIT, pump (See WATER PUMP)
3024625	SHIM KIT, pinion bearing cage assembly, rear axle
	1 3024624 SHIM (.003" thick)
	1 3024626 SHIM (.005" thick)
	1 3024627 SHIM (.010" thick)
3046168	SEAL AND GASKET KIT, transmission (2-speed forward, 1-reverse)
	1 3021053 SEAL, oil, shifter shaft
	2 3021056 GASKET, strainer and core cover
	1 3021058 RING, seal
	1 3027012 RING, seal, cover
	1 3031847 CUP, cut-off plug
	1 3035714 RING, seal, hi-clutch
	1 3035745 RING, seal
	1 3039422 SEAL, oil, valve
	2 3042138 SEAL KIT (Includes expander)
	2 3042146 SEAL KIT (Includes expander)
	1 3042151 SEAL KIT (Includes expander)
	6 3044377 STRIP, locking, pump retainer
	1 3044382 RING, seal
	1 3044386 GASKET, oil pump
	1 3044390 GASKET, housing, transmission
	1 3044400 RING, seal, suction tube nut
	1 3044402 GASKET, cover, oil pump
	1 3044409 SEAL, oil
	1 3044410 GASKET, rear cover
	1 3044411 RING, seal, rear cover
	2 3044422 RING, seal, 2nd turbine
	6 3044460 TAB, lock, piston housing
	2 3044462 SEAL, oil, output shaft
	2 3044474 GASKET
	1 3044485 GASKET, trimmer valve
	2 3044489 GASKET, cut-off plug
	1 3048782 GASKET, control valve
	1 3051197 DIAPHRAGM AND SEAL ASSEMBLY
	1 3054475 GASKET, pump, torque converter
	1 ----- SEAL, oil (Not used-discard)
	1 ----- RING, seal (Not used-discard)
	1 ----- INSTRUCTION SHEET

PACKAGED PARTS

PACKAGE NO.	DESCRIPTION	
4027157	SLEEVE KIT (Not serviced, order parts listed below)	
	2	4025015 O-RING
	1	4026497 PISTON
	1	4026505 PIN, piston
	1	4026578 SLEEVE, cylinder
	1	4026981 RING SET, piston
	2	4254608 RETAINER, piston pin
4027283	GASKET KIT, intermediate	
	1	226012 GASKET, drain plug
	2	923376 O-RING, rear plate
	2	923649 O-RING, oil cooler
	4	923664 O-RING, oil cooler
	1	923684 O-RING, volute
	1	923814 O-RING, oil cooler
	1	923817 O-RING, drive housing
	1	923822 O-RING, water pump
	1	4020879 O-RING, rear plate
	1	4025019 GASKET, cover plate
	2	4025021 GASKET, cover plate
	1	4025072 GASKET, front plate
	1	4025074 GASKET, front cover
	1	4025097 O-RING, rear plate
	1	4025106 GASKET, inlet pipe
	2	4025120 GASKET, oil filter
	1	4025343 GASKET, cover
	1	4025367 GASKET, oil cooler
	1	4025622 GASKET, compressor bracket
	2	4025632 GASKET, oil cooler
	1	4026548 GASKET, inspection plate
	2	4026549 GASKET, cover plate
	1	4026887 GASKET, water pump
	1	4105456 GASKET, plug
	1	4255661 O-RING, adapter
	1	4336676 GASKET, timing hole
	1	4337740 GASKET, cover
	1	4349984 GASKET, oil cleaner
	1	4371289 GASKET, cover plate
4027785	GASKET KIT, cylinder head (Also order 1 GASKET 4027024)	
	2	4025101 GASKET, thermostat housing, lower
	1	4025106 GASKET, water inlet
	6	4025150 GASKET, injection nozzle
	1	4025472 GASKET, cylinder head cover
	1	4026579 GASKET, intake manifold
	6	4027014 GASKET, exhaust manifold
	1	4027598 GASKET ASSEMBLY, cylinder head (Includes 6 fire rings)

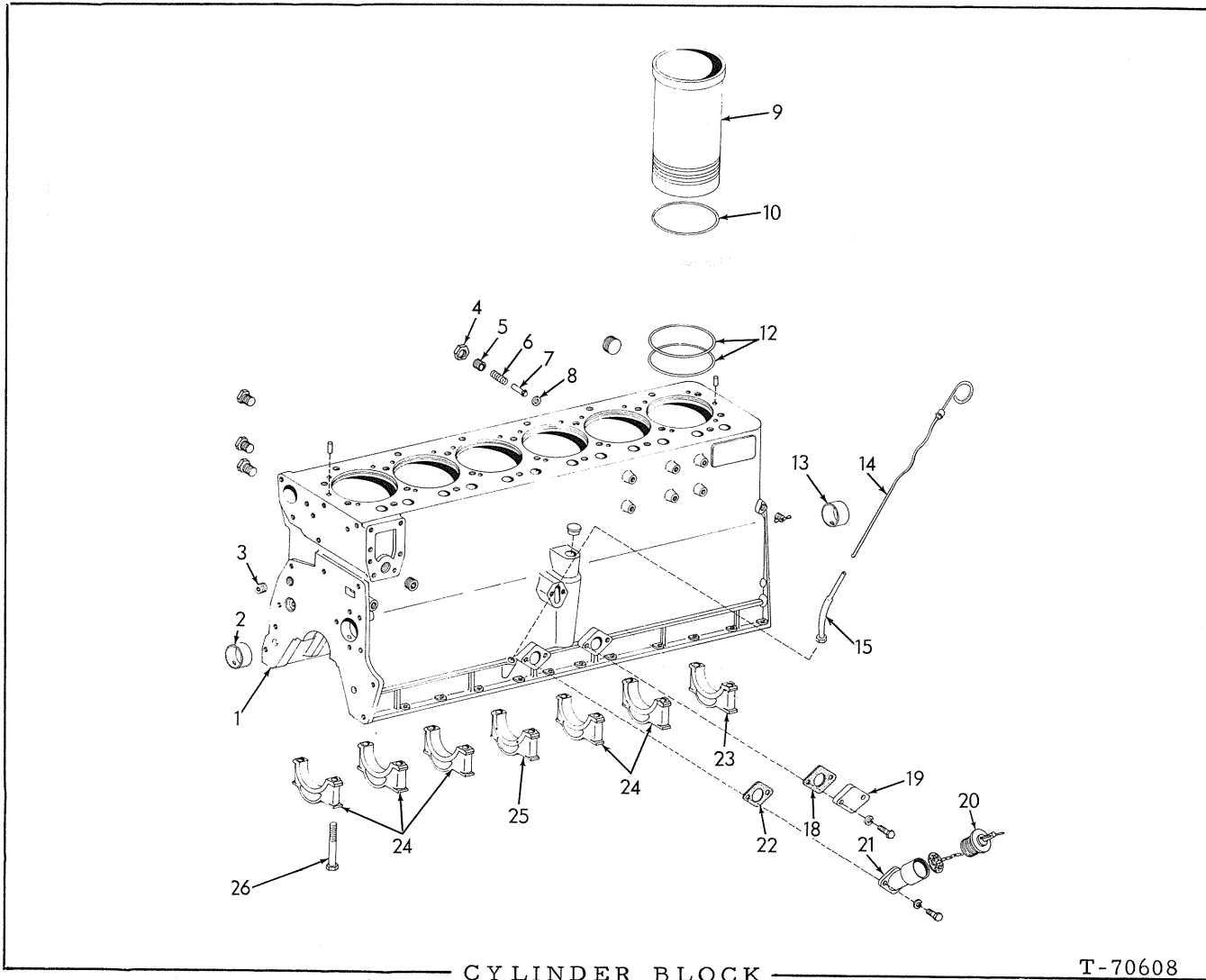
MEMO



ENGINE AND MOUNTING

T-70680

ITEM	PART NO.	QTY.	DESCRIPTION
1	4027155	1	ENGINE ASSY. (Less air cleaner, fan and starter)
	913105	6	CAPSCREW, 1/2" NF x 1-1/2"
	914487	6	NUT, safety, 1/2" NF
	912415	2	COCK, drain
2	3043879	2	SHIM, engine mounting (.0598" thick. Use as req'd)
3	3043878	2	BLOCK, engine mounting
4	3044877	1	BRACKET, engine mounting, left
	3044878	1	BRACKET, engine mounting, right
5	915790	4	CAPSCREW, 5/8" NF x 3"
	3026289	4	WASHER, plain
	916589	4	NUT, safety, 5/8" NF



CYLINDER BLOCK

T-70608

ITEM	PART NO.	QTY.	DESCRIPTION
1	4026943	1	BLOCK ASSEMBLY, cylinder (Includes PLUGS and items 2, 3, 8, 13, & 23 thru 26)
	917542	2	PIN, dowel, 7/16" x 3/4"
	918887	1	PLUG, pipe, 3/8" NPT
	918888	1	PLUG, pipe, 1" NPT
	919134	1	PLUG, pipe, 1/8" NPT
	904223	2	PLUG, pipe, ctsk., 1/2" NPTF
	917536	2	PIN, dowel, 1/2" x 1-3/8"
	908944	2	PLUG, pipe, ctsk., 1/2" NPT
	4025323	1	PLUG, pipe, oil gallery
	4254452	1	PLUG, distributor hole
	4255490	1	PLUG, pipe, 1/8"
	4255491	1	PLUG, pipe, 1/4"
	4255363	1	COCK, drain
2	{ 4025025	1	BEARING, camshaft, front (Std.)
	{ 4025259	1	BEARING, camshaft, front (.010" undersize)
3	4025392	1	PLUG, pipe, restrictor
4	4510836	1	SCREW, oil pressure regulating valve
	910847	1	NUT, jam, 3/4" NF
5	4025471	1	SPACER, oil pressure regulating valve

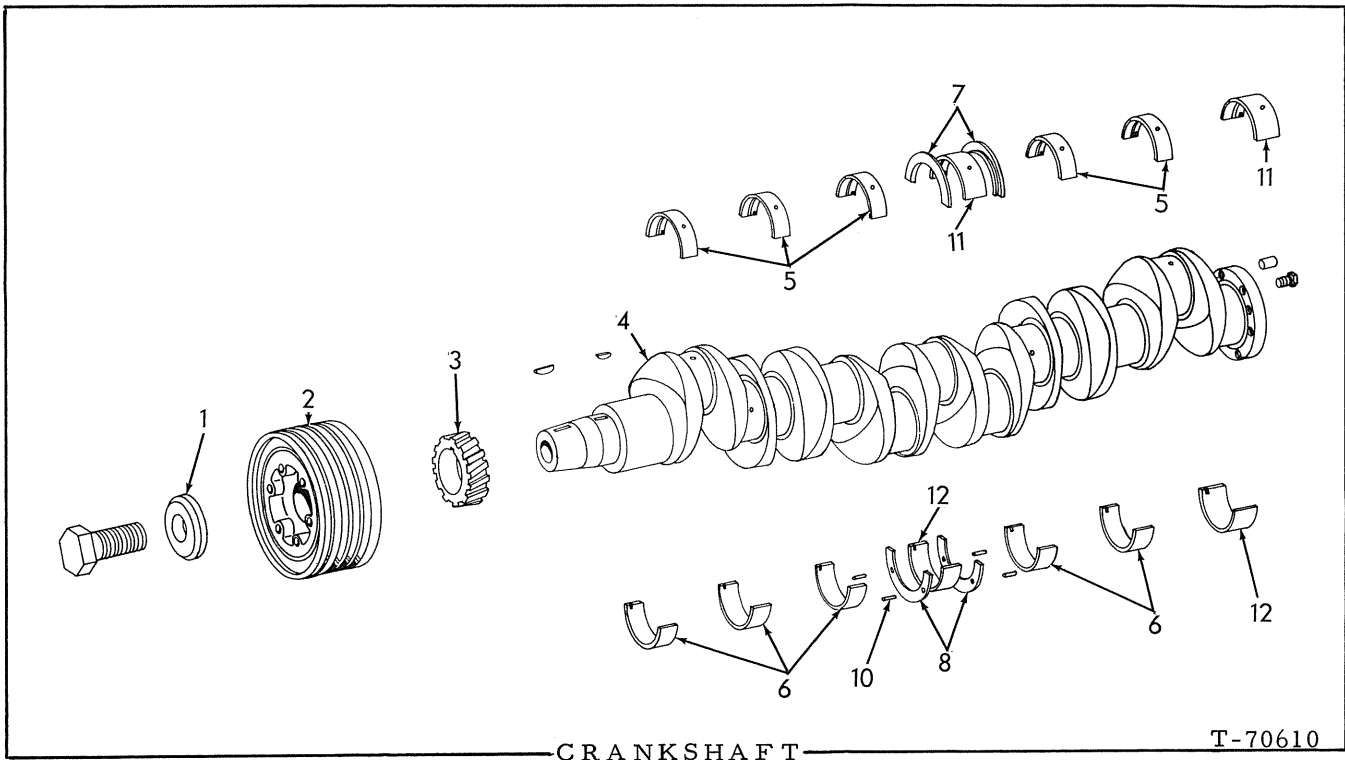
(Continued)

CYLINDER BLOCK (Continued)

ITEM	PART NO.	QTY.	DESCRIPTION
6	4500231	1	SPRING, oil pressure regulating valve
7	4507374	1	PISTON, oil pressure regulating valve
8	4507673	1	INSERT, oil pressure regulating valve
9	4026578	6	<input type="checkbox"/> SLEEVE, cylinder
10	4025298	-	SHIM, cylinder sleeve (.005" thick. Use as req'd)
	4025299	-	SHIM, cylinder sleeve (.010" thick. Use as req'd)
	4025300	-	SHIM, cylinder sleeve (.015" thick. Use as req'd)
	4025301	-	SHIM, cylinder sleeve (.020" thick. Use as req'd)
12	4025015	12	<input type="checkbox"/> O-RING, cylinder sleeve (Lower)
13	4025238	5	BEARING, camshaft (Int. & rear) (Std.)
	4025258	5	BEARING, camshaft (Int. & rear) (.010" undersize)
14	4026592	1	GAUGE, oil level
15	4026849	1	ADAPTER, oil level gauge
18	4025021	1	<input type="checkbox"/> GASKET, oil filler plate
19	4026382	1	PLATE, oil filler hole
	916269	2	CAPSCREW, 3/8" NC x 7/8"
	904206	2	LOCKWASHER, 3/8"
20	4354449	1	CLOSURE ASSY. (Serviced only as a unit)
21	4025716	1	ELBOW ASSY., oil filler (Includes item 20)
	914847	2	CAPSCREW, 3/8" NC x 1-1/2"
	904206	2	LOCKWASHER, 3/8"
22	4025021	1	<input type="checkbox"/> GASKET, elbow oil filler
23	4025247	1	CAP, rear main bearing (See Note)
24	4025245	5	CAP, intermediate & front main bearing (See Note)
25	4025246	1	CAP, center main bearing (See Note)
26	4025062	14	CAPSCREW, main bearing caps

NOTE: Replacement bearing caps are semi-finished and must be line-bored after installing.

(Also see PACKAGED PARTS)



CRANKSHAFT

T-70610

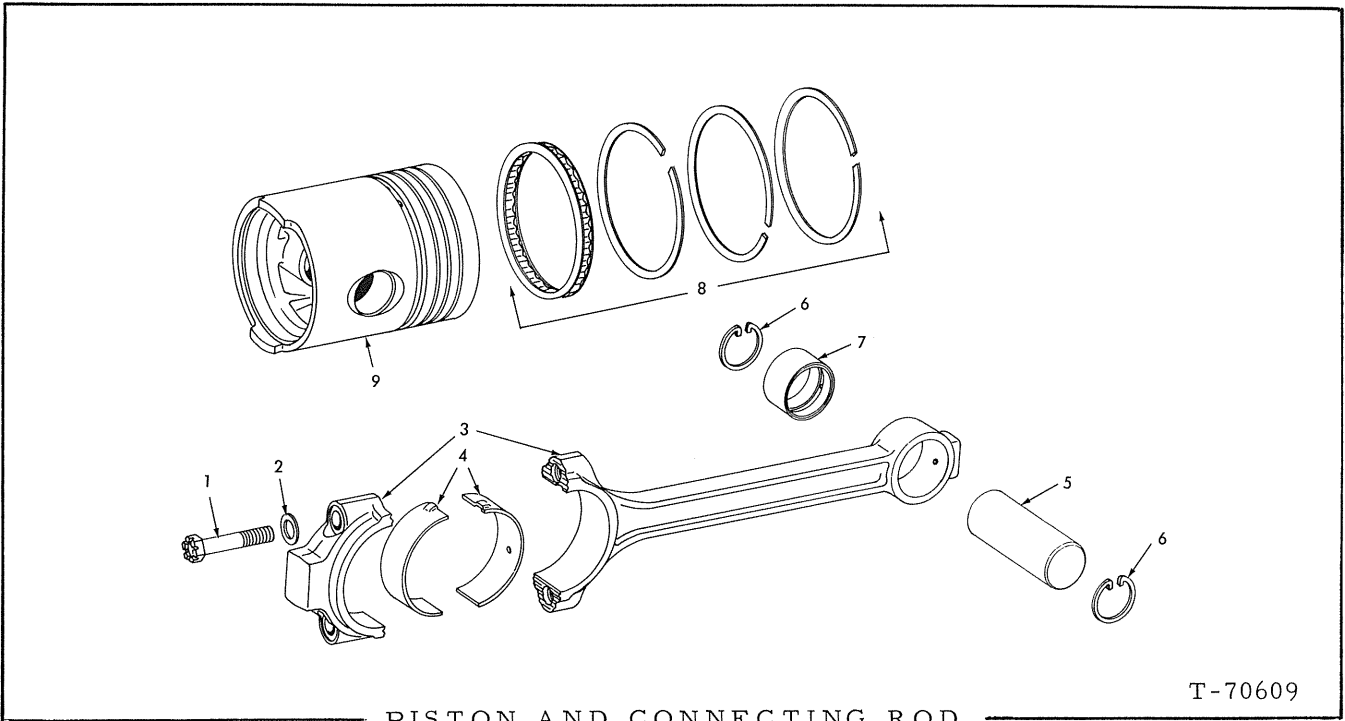
ITEM	PART NO.	QTY.	DESCRIPTION
1	4025115	1	WASHER, pulley
	918297	1	CAPSCREW, 1" NF x 2"
2	4025589	1	PULLEY, crankshaft
	905845	1	KEY, woodruff, 1/4" x 7/8"
3	4025041	1	GEAR, crankshaft
	905845	1	KEY, woodruff, 1/4" x 7/8"
4	4025478	1	CRANKSHAFT ASSEMBLY, (Includes PLUG)
	919840	1	PLUG, pipe, 1/4" NPT
5	4025006	5	BEARING, front & intermediate, upper (Std.)
	4025271	5	BEARING, front & intermediate, upper (.002")
	4025272	5	BEARING, front & intermediate, upper (.010")
	4025273	5	BEARING, front & intermediate, upper (.020")
	4025274	5	BEARING, front & intermediate, upper (.030")
	4025275	5	BEARING, front & intermediate, upper (.040")
6	4025007	5	BEARING, front & intermediate, lower (Std.)
	4025266	5	BEARING, front & intermediate, lower (.002")
	4025267	5	BEARING, front & intermediate, lower (.010")
	4025268	5	BEARING, front & intermediate, lower (.020")
	4025269	5	BEARING, front & intermediate, lower (.030")
	4025270	5	BEARING, front & intermediate, lower (.040")

(Continued)

CRANKSHAFT (Continued)

ITEM	PART NO.	QTY.	DESCRIPTION
7	4025010	2	FLANGE, thrust, upper (Std.)
	4025263	2	FLANGE, thrust, upper (.005")
	4025264	2	FLANGE, thrust, upper (.010")
	4025265	2	FLANGE, thrust, upper (.015")
8	4025011	2	FLANGE, thrust, lower (Std.)
	4025260	2	FLANGE, thrust, lower (.005")
	4025261	2	FLANGE, thrust, lower (.010")
	4025262	2	FLANGE, thrust, lower (.015")
10	4251746	4	PIN, groove, thrust flange
11	4025008	2	BEARING, center rear, upper (Std.)
	4025281	2	BEARING, center rear, upper (.002")
	4025282	2	BEARING, center rear, upper (.010")
	4025283	2	BEARING, center rear, upper (.020")
	4025284	2	BEARING, center rear, upper (.030")
	4025285	2	BEARING, center rear, upper (.040")
12	4025009	2	BEARING, center rear, lower (Std.)
	4025276	2	BEARING, center rear, lower (.002")
	4025277	2	BEARING, center rear, lower (.010")
	4025278	2	BEARING, center rear, lower (.020")
	4025279	2	BEARING, center rear, lower (.030")
	4025280	2	BEARING, center rear, lower (.040")

"ALWAYS GIVE MODEL AND SERIAL NUMBER WHEN ORDERING PARTS"

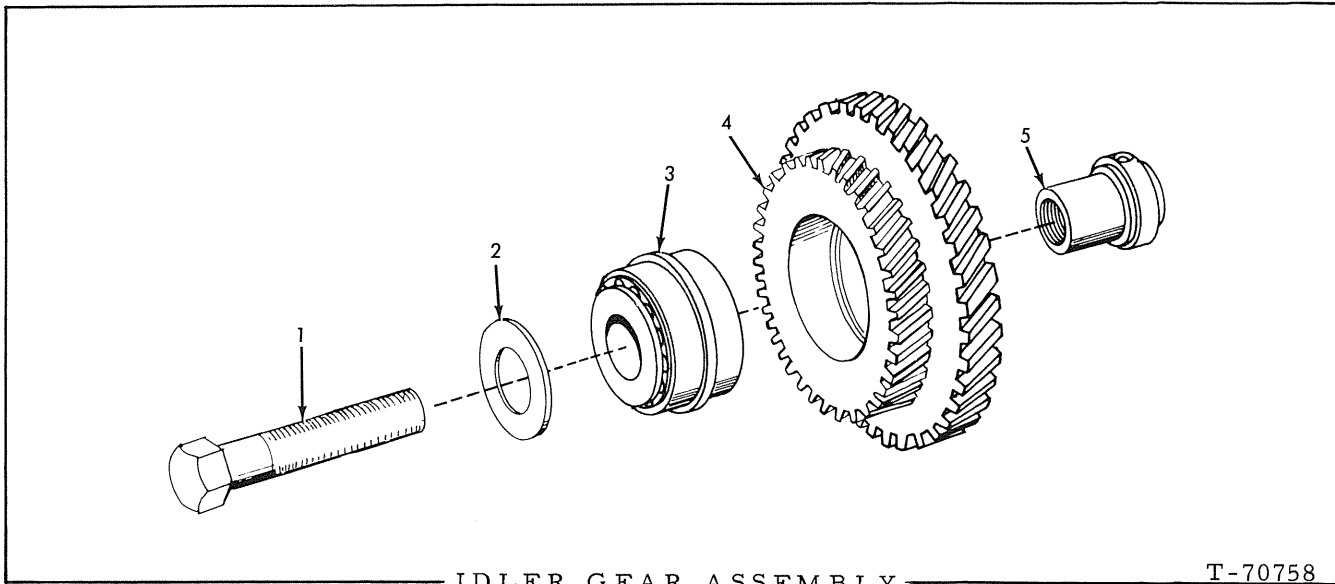


PISTON AND CONNECTING ROD

T-70609

ITEM	PART NO.	QTY.	DESCRIPTION
1	4026352	12	CAPSCREW, connecting rod
2	4025070	12	WASHER, flat, connecting rod
3	4026353	6	ROD ASSY., connecting (Includes items 1, 2 and 7)
4	4025030	12	BEARING, connecting rod (Std.)
	4025253	12	BEARING, connecting rod (.002")
	4025254	12	BEARING, connecting rod (.010")
	4025255	12	BEARING, connecting rod (.020")
	4025256	12	BEARING, connecting rod (.030")
	4025257	12	BEARING, connecting rod (.040")
5	4026505	6	□ PIN, piston
6	4254608	12	□ RETAINER, piston pin
7	4025031	6	BUSHING, connecting rod
8	4026981	6	□ RING SET, piston
9	4026497	6	□ PISTON

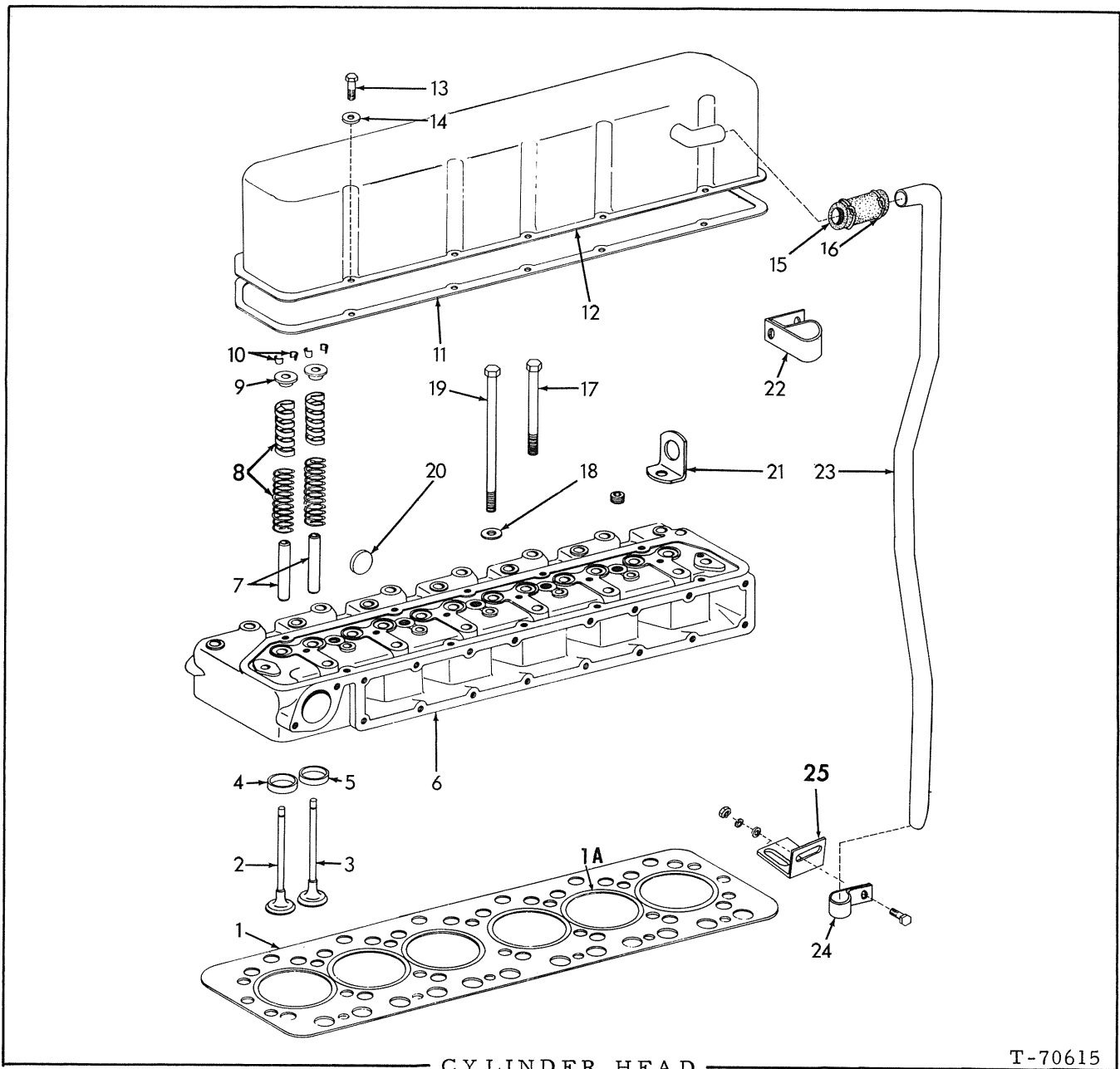
□ (Also see PACKAGED PARTS)



IDLER GEAR ASSEMBLY

T-70758

ITEM	PART NO.	QTY.	DESCRIPTION
1	921539	1	CAPSCREW, retaining idler gear
2	4025461	1	WASHER, idler gear capscREW
3	4025082	1	BEARING ASSEMBLY, idler gear
4	4026039	1	GEAR, idler
5	4020102	1	SHAFT, idler gear



CYLINDER HEAD

T-70615

ITEM	PART NO.	QTY.	DESCRIPTION
1	4027598	1	□ GASKET KIT, cylinder head (Includes item 1a)
1a	4027013	6	RING, fire
2	4025182	6	VALVE, exhaust
3	4025179	6	VALVE, intake
4	4025185	6	INSERT, exhaust valve seat
	4025585	-	INSERT, exhaust valve seat (Use as req'd) Requires remachining of cylinder head.

(Continued)

CY LINDER HEAD (Continued)

ITEM	PART NO.	QTY.	DESCRIPTION
5	4025186	-	INSERT, intake valve seat (Used as req'd) Requires remachining of cylinder head.
6	4026228	1	HEAD ASSEMBLY, cylinder (Includes items 4, 7, 20 and PLUGS indented below)
	920340	5	PLUG, pipe, ctsk., 3/4" NPT
7	4020682	12	GUIDE, intake and exhaust valve
8	4025242	12	SPRING ASSEMBLY, intake and exhaust (Includes DAMPENER) (Serviced only as a unit)
9	4343799	12	RETAINER, valve spring, intake and exhaust
10	4376497	24	LOCK, half, valve spring retainer
11	4025472	1	<input type="checkbox"/> GASKET, cylinder head cover
12	4025555	1	COVER, cylinder head
13	4153776	10	CAPSCREW, cylinder head cover
14	4025491	10	WASHER, cylinder head cover
15	4650229	1	HOSE, breather tube
16	4253977	2	CLAMP, hose
17	4025164	20	CAPSCREW, cylinder head (short)
18	4025165	26	WASHER, cylinder head capscrew
19	4025166	6	CAPSCREW, cylinder head (long)
	913544	6	WASHER, plain, 13/32" I. D.
	904206	6	LOCKWASHER, 3/8"
20	4255107	5	PLUG, core hole
21	4025177	2	EYE, lifting
22	4025621	1	CLAMP, breather tube (upper) (See INTAKE MANIFOLD for fasteners)
23	4025993	1	TUBE, breather
24	4025914	1	CLAMP, breather tube (lower)
	915408	1	CAPSCREW, 3/8" NC x 3/4"
	911115	1	WASHER, plain, SAE std., 3/8"
	904206	1	LOCKWASHER, 3/8"
	910324	1	NUT, 3/8" NC
25	4025992	1	BRACKET, breather tube (lower)

(Also see PACKAGED PARTS)